Work Orden	er ID 124219 4 11:58:59 AM			*124	1219*							Page 1
Revision ID: Item Name:		Qty: 1.00	*1* *1*	Accept	*N900  Cust Item Customer:	<b>n</b> *	Setup	Start Stop	*NS1* *NS2*			
Approvals:	Process Plan: MC5  QC:		Date: 14 09 - 16	Tooling: _ SPC (Y/N):		Pate:	_			Start Stop		R1* R2*
Sequence ID/ Work Center II		Operation Description			Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	or									-	
D3651	Rev B											
100	Pick Kit			0.00				·				
*100* Packaging Packaging		Мето		0.00				2	F	E.	(	OCT 2 3 2014
110				0.00			•					
*110* Small Fab	Small Fa	b <b>Memo</b>		0.00				2	FF	<del>-</del>	<u>-</u>	OCT 2 3 2014
Small Fab		1-Assemble Proseal 700 D3651-1 usi	as per dwg D36512- Seal all fire wall sealant as per dwg E ng 3M high per formance con 1: 1165623	mating surfaces and ga	ps using <u>Ø}</u> 3-install per dwg							
120	QC5- Ins	pect part comple	eteness to step on W/O	0.00								, .
*1 20* <sub>QC</sub>		Memo	•	0.00			DAS 30 9-89	2				<u>ullal:</u>

Quality Control

DQA:			Date:												
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only									
QA Closed.			Date.									·			
Work Orde	er:					DISPOSITION				AGAINST [	PEPARTMENT	/PROCESS			
······································	_					Rework			Skid-tube	Crosstube	$\neg$	Water Jet	Engineering		
Part N	lo.					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality		
	-					Use-as-is		l .	noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	lo.					Suspected Unapproved			Large Fab	Composite	7	Supplier			
	_						'								
Root					Desci	ription of work order update	1	nitial	Acti	on	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector		
Design															
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Equip/Tooling		i													
Handling/Pre											1				
Material	_					•									
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Landii						General		1		г	٦	Г			
	$\overline{}$	Bending				Bend		1	rogram	F	Outside Dim	<u> </u>	Pressure/Forced		
	Centre Not Concentric					BOM/Route	_	Grain		F	Over/Under		Set-up		
	Cracks				$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa			Part Incorre		Temperature/Cure Weld		
	Crimp/Kink/Ripple/Wave					Burrs	<u> </u>	1	ion Incomplete/Un	· -	Part Lost/M	- h	<del></del>		
	Cuffs					Countarink	<u> </u>	4	ions Incomplete/U	nciear	Part Moved		Wrong Stock Pulled		
	Crushing					Countersink	-	1 -	ned/off center	}	Positioned \ Power Loss/	_	Other		
	Heat Treat Inspection Strip in Tube					Cut Too Short	$\vdash$	Mislabe Misread		L	rower Loss/	Juige _	Toniei	_	
	_	inspectior Marks/Ch		rube	<u> </u>	Drawing Drill Holes	⊢	Off-set	A			· <del></del> -			
	$\dashv$	rviarks/Cn Turning Se				Finish		4	Calibration		<del></del>			_	
		Wave/Tw			-	Fit/Function	<u> </u>	4	Sequence				· · · · · · · · · · · · · · · · · · ·	-	
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Work Order ID	124219
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## \*124219\*

Page 2

September-11-14 11:58:59 AM Item ID: D3651-041 Accept \*N900040100\* Setup Start **Revision ID: Item Name:** Aft Base Assembly **Start Date:** 9/10/14 Start Qty: 1.00 \*1\* **Cust Item ID:** Required Date: 9/10/14 Req'd Qty: 1.00 \*1\* **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Stamp Number 130 Identify as per dwg & Stock Location: 0.00 DAS \*130\* 30 Packaging 9-89 Memo 0.00 Packaging

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

**Quality Control** 

Memo

0.00

DQA:			Date:			WORK ORDER NON	DART							
QA Closed:			Date:			WORK ORDER NON-	AEROSPACE							
QA closed.			Dute.			DISPOSITION								
Work Orde	er:					DISPOSITION						PARTMENT,		-,
						Rework		Skid-tube Crosstube			_		Water Jet	Engineering
Part N	١o.					Scrap			Machining Small Fab			4	d. Eng. Coor.	Quality Other
NCD A						Use-as-is		Inern	noforming Large Fab	Finishing Composite	_	Rec/Stor	e/Packaging Supplier	
NCR I	¥O.	<u></u>				Suspected Unapproved			raige ran	Composite		J	Juppliet	
Root		- "			Desci	ription of work order update		nitial	Ad	ction		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
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Doc/Data														·
Equip/Tooling														
Handling/Pre														
Material		1												
Operator		4												
Offset/Setup														
Process Supplier														
Training														
Transport							ľ							
Unapproved									ļ					
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Landi	ng (	Sear	-			General			•					7
		Bending				Bend		Folio/P	rogram		Ŀ	Outside Dim	ensions	Pressure/Forced
		Centre Not Concentric				BOM/Route		Grain			L	Over/Under	<b></b>	Set-up
		Cracks				Broken/Damage/Defect		Hardwa			_	Part Incorred		Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs	┝	₹ '	ion Incomplete/l	•	<u> </u>	Part Lost/Mi	ssing	Weld
	Cuffs					Contamination	-	4	ions Incomplete		<u> </u>	Part Moved	L_	Wrong Stock Pulled
	Crushing					Countersink	-	1 -	ned/off center		<u> </u>	Positioned V		٦
Heat Treat						Cut Too Short		Mislabe				Power Loss/	Surge	Other
	Inspection Strip in Tube					Drawing	╙	Misread						
		Marks/Ch				Drill Holes	$\vdash$	Off-set						
	<u> </u>	Turning S	•			Finish		4	Calibration					·
	1	Wave/Tw	ist in Tub	e		Fit/Function	1	Out of Sequence						

## **Picklist Print**

September-11-14 11:58:59 AM

Work Order ID: 124219

\*124219\*

Parent Item:

\*D3651-041\*

#

**Start Date:** 9/10/14

Required Date: 9/10/14

Date

Issued

Start Oty: 1.00

Required Oty: 1.00

Comments:

Item Name

IPP Rev:A New Issue 07-09-27

IPP Rev:B

DD verified by: EC

Component Item ID/

IPP Rev:C ecn1162 Replacement Mfg/ DD verified by: EC

CR3523-4-02 \*CR3523-4-02\* RIVET

\*D3651-043\*

Manufactured No

130415 ST317 m124198

Location

Location

ST207

Location

ST506

m126826

428 110

Each

8.0000

Loc Code

\*\*

OCT 2 3 2014

D3651-1

D3651-043

Flange Weldment

Manufactured No 94016

95811

110

11.0000

\*\*

OCT 2 3 2014

Gasket

D3651-11

Manufactured No

Loc Oty 11 11

110

Loc Code

5.0000

Loc Code

\*\*

FF

OCT 2 3 2014

\*D3651-11\* Gasket

\*D3651-1\*

st507

Location

Loc Oty

5

5

D3651-041

Parent Item Name: Aft Base Assembly

Item ID

ECN 1113P 08-01-22 DD verofoed by: EC 08-04-02

Purch

Purchased

No

**Primary** 

Item Location

Last

Route Location

100

Unit of Seq ID

Loc Qty

Loc Qty

502

74

8

Each

Each

Measure Each

Hand 502.0000

Loc Code

Oty on

58

\*\*

Qty per Kit

58

FF

Qty

Issued

OCT 2 3 2014

Status

Page 1

Total

Oty

DQA:			Date:													
						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:							W	ork Order up	odate only				
Marile Ond						DISPOSITION			AGAINST	. DE	PARTMENT	/PROCESS				
Work Orde	er:					Rework			Skid-tube Crosstube	$\Box$	1	Water Jet	Engineering			
Part N	١٥.					Scrap		Machining Small Fab		Pro	d. Eng. Coor.	Quality				
NCR No.						Use-as-is Suspected Unapproved			noforming Finishing Large Fab Composite	`—	Rec/Sto	re/Packaging Supplier	Other			
Root					Desci	ription of work order update		nitial	Action		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector			
Design																
Doc/Data																
Equip/Tooling																
Handling/Pre			:	•												
Material																
Operator																
Offset/Setup																
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Supplier																
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Transport																
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	-	Bending				Bend	_	•	rogram	$\vdash$	Outside Dim	<del>-</del>	Pressure/Forced			
		Centre Not Concentric				BOM/Route		Grain		<u>_</u>	Over/Under		Set-up			
	-	Cracks				Broken/Damage/Defect		Hardwa		$\vdash$	Part Incorred	-	Temperature/Cure			
	Crimp/Kink/Ripple/Wave				_	Burrs	_	1	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	ssing	Weld			
	Cuffs				<u> </u>	Contamination			ions Incomplete/Unclear	L	Part Moved	L	Wrong Stock Pulled			
	Crushing					Countersink		•	ned/off center	$\vdash$	Positioned V	_	1			
	Heat Treat					Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other			
	Inspection Strip in Tube					Drawing		Misread								
	-	Marks/Ch				Drill Holes		Off-set								
	-	Turning S				Finish		1	Calibration							
	Wave/Twist in Tube					Fit/Function		Out of 9	Sequence							

## **Picklist Print**

September-11-14 11:58:59 AM

Work Order ID: 124219

\*124219\*

**Parent Item:** 

D3651-041

\*D3651-041\*

Parent Item Name: Aft Base Assembly

**Start Date:** 9/10/14

Required Date: 9/10/14

Start Qty: 1.00

Required Qty: 1.00

D3651-13

Manufactured

No

110

Each

11.0000

\*\*

OCT 2 3 2014

Outside Doubler

Location st507

94690 95404 Loc Oty 11 2 9 Each Loc Code

D3651-9

Manufactured

No

110

4.0000

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OCT 2 3 20

Inside Doubler

Location Loc Qty ST506 94595 1 95376

Loc Code

DQA:		<del>.</del>	Date:			WORK ORDER NON	DART								
QA Closed:			Date:			WORK ORDER NON-	AEROSPACE								
	· ·		<u>, "</u>			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Orde	er:					0			ا ماریم اینان	Crosstube	7	Water Jet	Engineering		
Part No.						Rework Scrap Use-as-is			Skid-tube Machining noforming	Small Fab Finishing		d. Eng. Coor.	Quality Other		
NCR N	No					Suspected Unapproved			Large Fab	Composite	<u> </u>	Supplier			
Root					Desci	ription of work order update	I	nitial	Acti	ion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector		
Design										•					
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Handling/Pre															
Material															
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	Centre Not Concentric					BOM/Route		Grain			Over/Under	<del>                                     </del>	Set-up		
	Cracks					Broken/Damage/Defect	_	Hardwa	ire	_	Part Incorred	<del></del>	Temperature/Cure		
	Crimp/Kink/Ripple/Wave					Burrs	<u> </u>	Inspect	ion Incomplete/Un	nqualified	Part Lost/Mi	ssing	Weld		
	Cuffs					Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved	·	Wrong Stock Pulled		
	Crushing					Countersink		Misalig	ned/off center		Positioned V				
	Heat Treat					Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
	Inspection Strip in Tube					Drawing		Misread	t t						
	М	arks/Ch	atter			Drill Holes		Off-set							
	Tu	rning Se	equence			Finish		Out of	Calibration						
	Wave/Twist in Tube					Fit/Function		Out of	Sequence						